

Date: Friday, 18/07/2008 1:10:45 PM  
User: Julie Lecocq

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : SEAT SUPPORT ASSEMBLY  
Job Number : 40659  
Estimate Number : 13327  
P.O. Number :  
This Issue : 18/07/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D3784041  
First Issue : / / Type : SMALL / MED FAB Drawing Number : D3784 REV B  
Previous Run : 05010 Drawing Revision : B  
Material :  
Due Date : 06/08/2008 Qty: 2 Um: Each  
Written By :  
Checked & Approved By : JUD 08.7.18  
Comment : Est Rev:A 08-05-19 new issue DD verified by:ec  
Est Rev:B 08-07-18 revB as per dwg DD verified by:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

2.0 D37701 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Tube

batch: B40713

NO QTY'S  
SAD 08/08/11

(2)

3.0 D3763041 End Fitting Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

End Fitting Assembly

batch: B40684-2

B# 41158

NO QTY'S  
SAD 08/08/11

(P12) (2)

4.0 D3763045 End Fitting Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

End Fitting Assembly

batch: B40687

NO QTY'S

FF 08-08-11

(2)

5.0 AN52510R20 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M108559

AS 08/08/11

(2)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3784-041 PAR #: N/A Fault Category: Large FAS NCR: Yes No DQA: 10 Date: 08.08.21  
D412-769-043044 QA: N/C Closed: 12 Date: 08/08/21

NCR: <u>40659</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.08.12	8	D3763-041 END FITTING NOT FITTING CORRECTLY (QTY (2) ONLY)	PE 08.08.12 QSS 042	GRIND WELD SLIGHTLY (PE QSS 042 08.08.12) GRIND WAS OVERDONE POSSIBLE STRUCTURAL PROBLEM RECOMMEND SCRAP	gad 08/08/12	C 08/08/12	PE 08.08.12 QSS 042	S 08/08/12
		RC: HUMAN ERROR		→ Replaced on <del>different sets</del> replace				

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 1:10:46 PM  
User: Julie Lecocq

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: SEAT SUPPORT ASSEMBLY

Job Number: 40659

Part Number: D3784041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

batch:

M104885

(or NAS1149D0332J) batch:

JS 08/08/01 (x2)

7.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

batch:

M107665

JS 08/08/01 (x2)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3784

SAN 08/08/12 (x2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/12 (x2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and Stock

Location:

35

8/8/12

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/2012

Job Completion



U 8.08.12

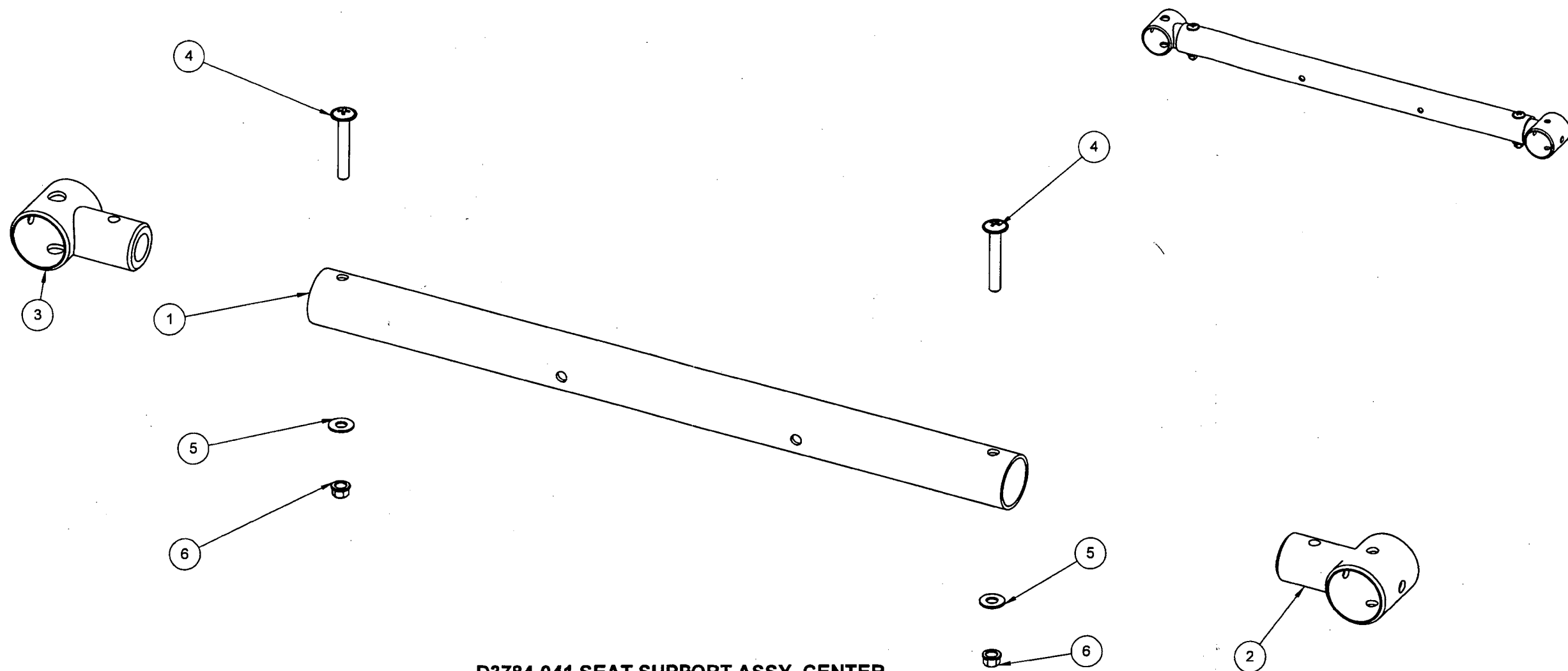
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3784-041 SEAT SUPPORT ASSY, CENTER**

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3770-1	TUBE	1
2	D3763-041	END FITTING ASSY	1
3	D3763-045	END FITTING ASSY	1
4	AN525-10R20	SCREW	2
5	NAS1149D0332J	WASHER (AN960JD10L)	2
6	MS21042L3	NUT	2

△  
B  
△  
B  
△  
B  
△  
B

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

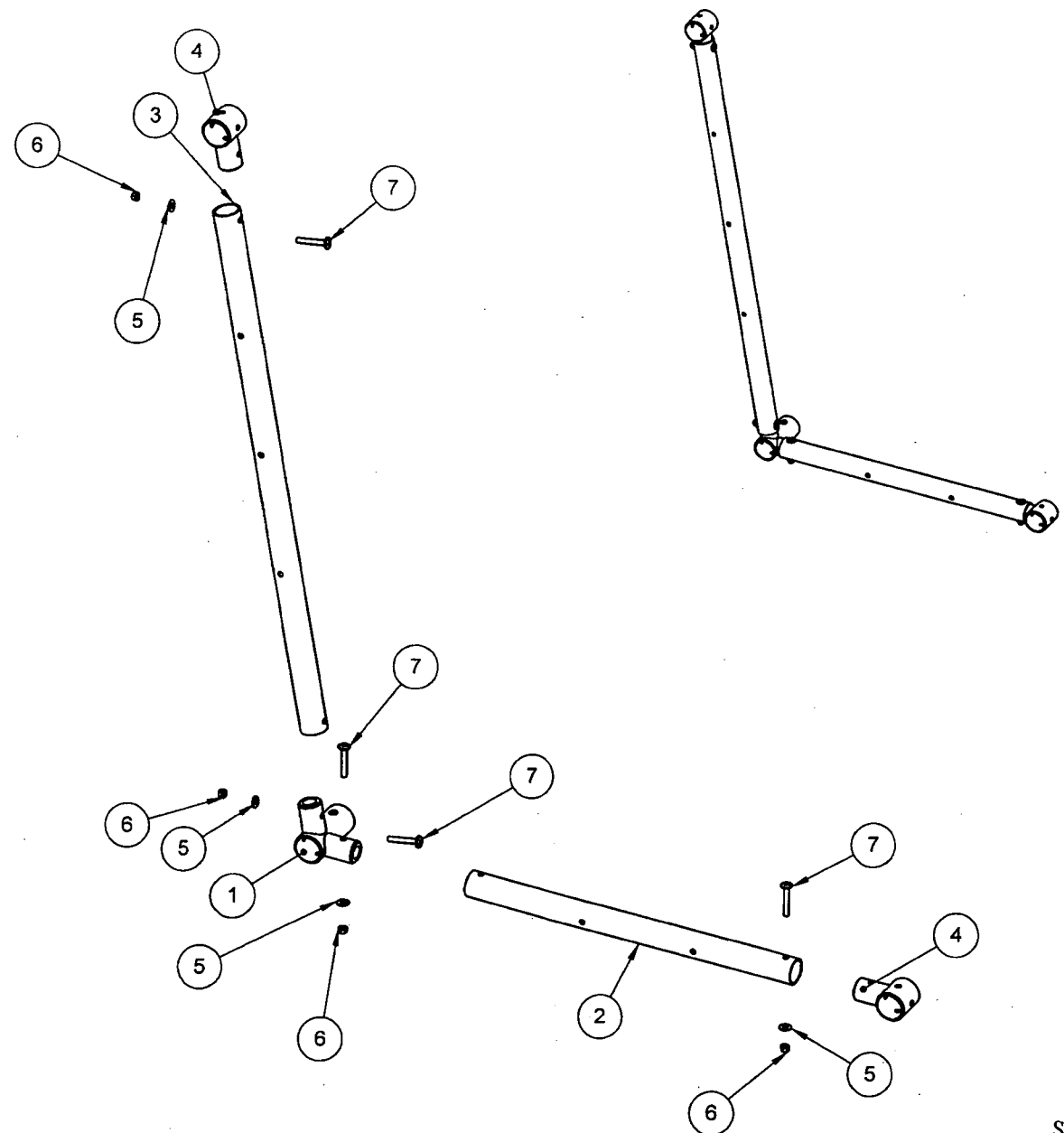
B	HARDWARE CHANGE, ASSY CHANGE	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	<b>D3784</b>	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	<b>SEAT SUPPORT ASSEMBLY</b>	NTS
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WITHOUT NOTICE  
WORK ORDER  
NO. 42657

RELEASED  
08.07.10

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-043	END FITTING ASSY, LH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	NAS1149D0332J	WASHER (AN960JD10L)	4
6	MS21042L3	NUT	4
7	AN525-10R20	SCREW	4

△  
B  
B  
B



**D3784-043 SEAT SUPPORT ASSY, LH**

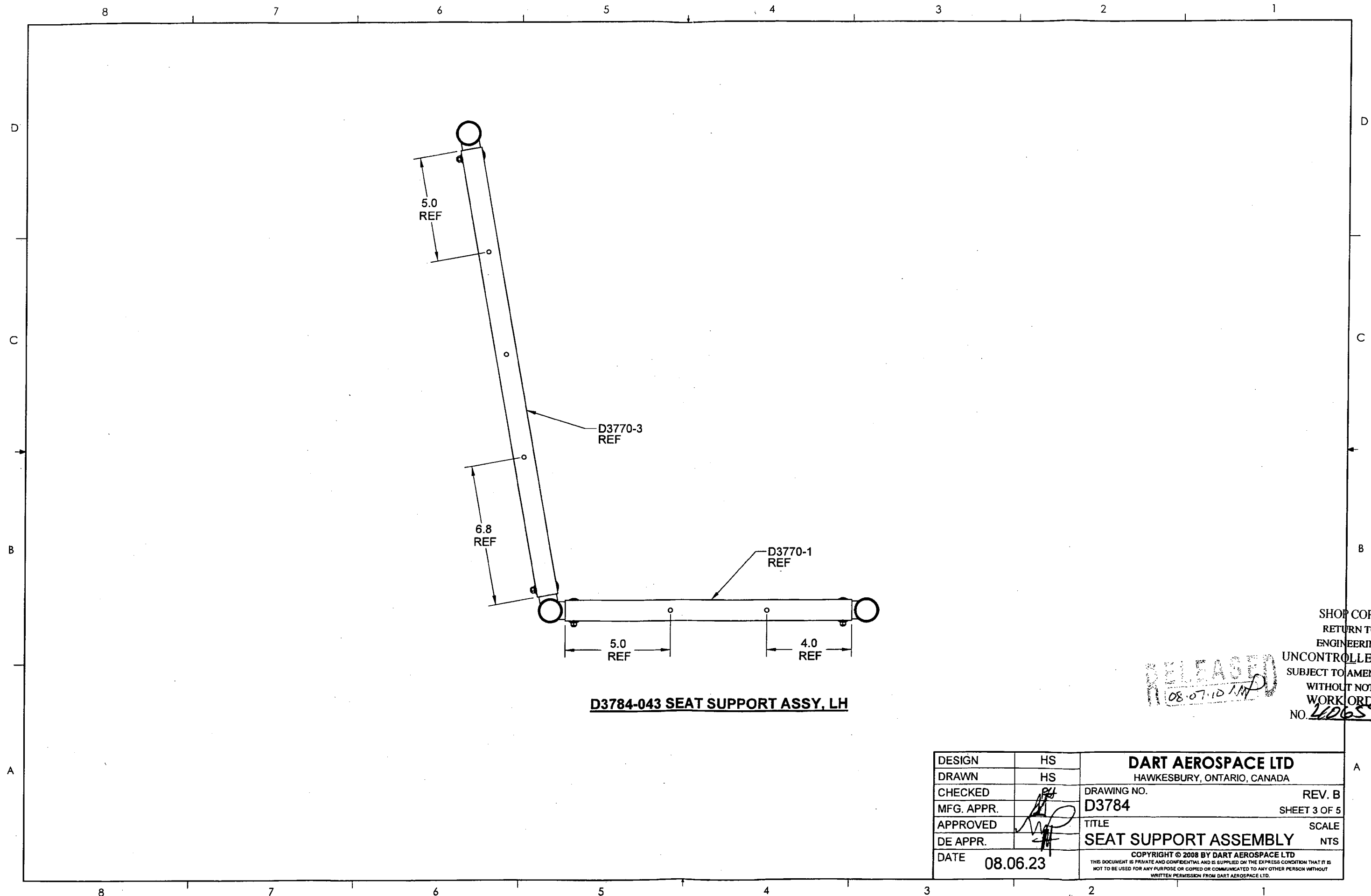
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

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MFG. APPR.	MD	<b>D3784</b>	SHEET 2 OF 5
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MFG. APPR.	<i>MP</i>	<b>D3784</b>	SHEET 3 OF 5
APPROVED	<i>MP</i>	TITLE	SCALE
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8 7 6 5 4 3 2 1

D

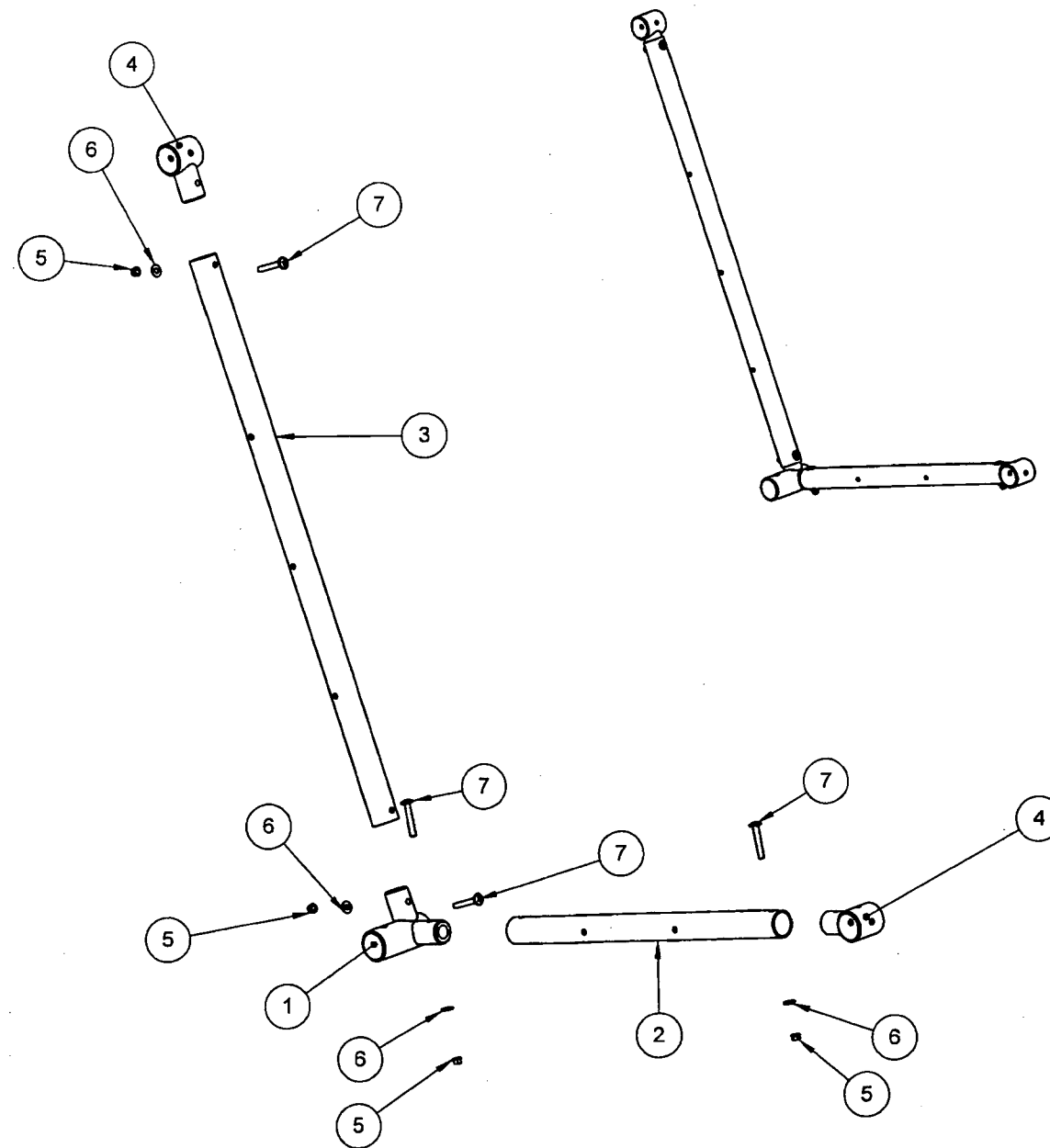
C

B

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-044	END FITTING ASSY, RH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	MS21042L3	NUT	4
6	NAS1149D0332J	WASHER (AN960JD10L)	4
7	AN525-10R20	SCREW	4

B  
B  
B



**D3784-044 SEAT SUPPORT ASSY, RH**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

8 7 6 5 4 3 2 1

D

C

B

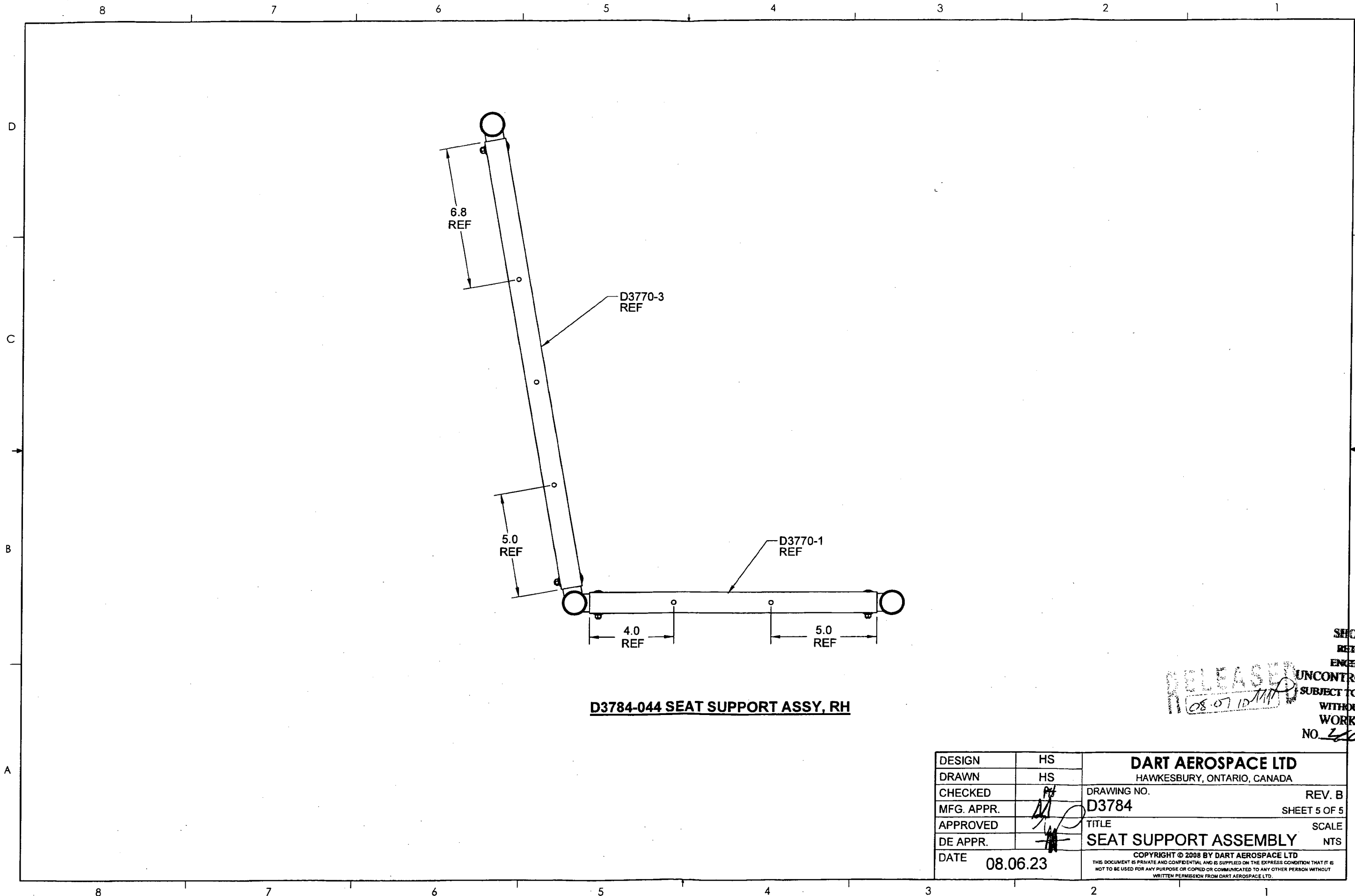
A

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MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE <b>SEAT SUPPORT ASSEMBLY</b> SCALE NTS
DE APPR.	<i>[Signature]</i>	
DATE	08.06.23	

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CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	MT	<b>D3784</b>	SHEET 5 OF 5
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